

Date: Wednesday, 5/31/2006 7:32:53 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FOLDING STEP WELDMENT RH
Job Number	: 27270		
Estimate Number	: 10697		
P.O. Number	: N/A	Part Number	: D3388042
This Issue	: 5/31/2006 S.O. No. : N/A	Drawing Number	: D3388 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LARGE FAB ASSY	Drawing Revision	: A
Previous Run	: 27220	Material	: N/A
Written By	: <i>SEE COMMENT BELOW</i>	Due Date	: 6/18/2006
Checked & Approved By	: <i>06.05.31</i>	Qty:	5 Um: Each
Comment	: Est. B 05.06.10 Added Step 11 KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2622120C	Extrusion
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

D2622-120C extrusion

Batch: *327077*

06.07.04 5

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1
 CUT D2622-120C extrusion 85.15" long as per Dwg D3388

Deburr and bevel ends for welding

06.07.04 5

06.07.04 5

3.0	D2734	206 Step Endplate
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

206 Step Endplate

Pick:

Qty	Part Number	Description	Batch
2	D2734	End Cap	<i>324402</i>

06.07.04 5

4.0	D33872	Arm
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Arm

Pick:

Qty	Part Number	Description	Batch
2	D3387-2	Arm	<i>327289</i>

06.07.04 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Wednesday, 5/31/2006 7:32:53 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FOLDING STEP WELDMENT RH

Job Number: 27270

Part Number: D3388042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld arms and (1) end cap as per Dwg D3388.

Grind end cap welds flush

Dwg Rev: A

A/R AL ROD Batch: M100660

FF 06-07-06 5
L.E. 06-07-06 5

6.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

06-07-06 (5)

06/07/06 (5)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAP 06-07-08 (5)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld last end cap as per Dwg D3388.

Inspect for foreign objects as per QSI 024.

Grind end cap welds flush

Dwg Rev: A

A/R AL ROD Batch: M15689

L.E. 06-07-18 5
FF 06-07-19 5

9.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

QC5/9 -> PD 06-07-19 (5)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch up Chemical Conversion Coat as per QSI 005 4.1

a.m. 06-07-19 (5)

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

SC 06/07/19 (3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
06-07-10	7.0	QC 3 for static inspection. perm. change QC 3 by 06-07-10		06-08-10			06-07-10

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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Process Sheet

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Drawing Name: FOLDING STEP WELDMENT RH

Job Number: 27270

Part Number: D3388042

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3388 and QSI 005 4.4

FC

06 07 20

(1)

ALM

06-07-20

(H)

13.0

QC3/5

INSPECT WORK/WING WALK



Comment: INSPECT WORK/WING WALK

Jan 31 (5)

14.0

D2808

Spacer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Spacer

Pick:

Qty Part Number Description Batch

1 D2808

Spacer

1327564

Press spacer into D3387-2 arm as per Dwg D3387

SAN 06-08-01

(5)

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-08-01 (5)

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location

GA Jan 08-01 (5)

17.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



u 06-08-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
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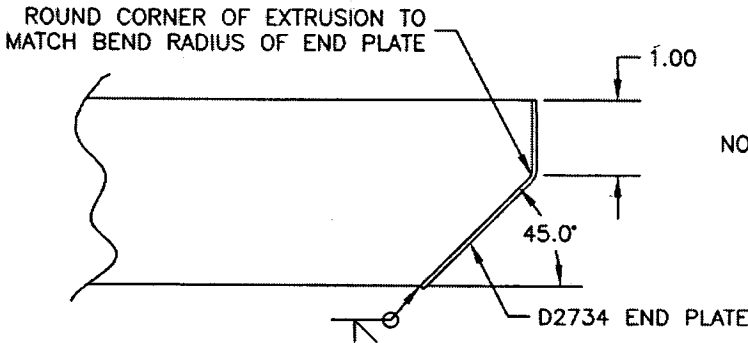
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

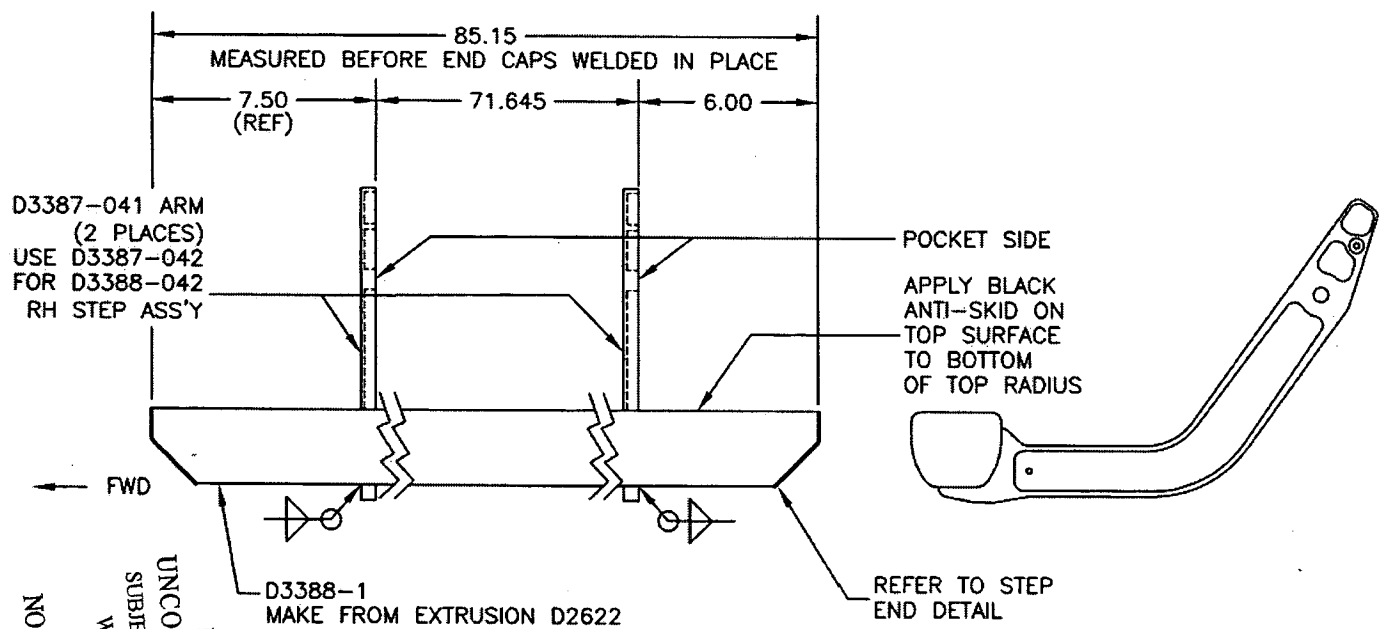
DART

RELEASED
05.03.11



NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004

TYPICAL STEP END DETAIL
NOT TO SCALE



D3387-041 ARM
(2 PLACES)
USE D3387-042
FOR D3388-042
RH STEP ASS'Y

POCKET SIDE
APPLY BLACK
ANTI-SKID ON
TOP SURFACE
TO BOTTOM
OF TOP RADIUS

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27270

D3388-041 LH STEP ASSEMBLY (SHOWN)
D3388-042 RH STEP ASSEMBLY (OPPOSITE)

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
WELD PER DART QSI 004 UNLESS OTHERWISE NOTED
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ENTIRE ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

DESIGN	05.01.20	DRAWN BY	05.01.20	DART AEROSPACE LTD
CHECKED		APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	05.01.20	DRAWING NO.	D3388	REV. A
		TITLE	STEP WELDMENT	SHEET 1 OF 1
A			NEW ISSUE	SCALE
				NTS

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